DART aerospace
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

# PURCHASE ORDER

**Purchase Order ID PO12546**

**Purchase Order Date** 9/10/10
**PO Print Date** 9/10/10



**Order From :** VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

| | | | |
|---|---|---|---|
| **Contact Name** | | **Buyer** | Chantal Lavoie |
| **Vendor Phone** | 800 363 6646 | **Requisition Nbr** | |
| **Vendor Fax** | 514 339 1105 | **Tax Resale Nbr** | 10127-2607 |
| **Vendor Account Nbr** | | **Terms** | Net 30 |
| | | **Currency** | CAD |
| | | **FOB** | |

**Ship To :** DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED 10/9/17

| Line Nbr | Reference / Revision ID / Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|---|---|---|---|---|---|---|---|
| 1 | M303R1.000 | 303 Round Bar 1.00 | 9/15/10<br>Yes | 24.00<br>f | Yours ppd | $6.6667 | $160.00 |
| | | **Special Inst:** | MATERIAL: 303 SS ROUND BAR<br>NOTE: AISI 304/316 NOT ACCEPTABLE | | | | |
| 2 | M304S16GA<br>CL 10/9/17 | 304/316 Sheet .063 | 9/15/10<br>Yes | 160.00<br>sf | Yours ppd | $5.2500 | $840.00 |
| | | **Special Inst:** | MATERIAL: AISI 304/316 SS SHEET<br>ANNEALED 2B FINISH<br>AS PER MIL-S-5059 OR AMS 5513 (304)<br>OR AMS 5524 (316) OR ASTM A240 OR<br>ASME SA240 | | | | |
| 3 | M6061T6A1.000W.125<br>CL 10/9/17 | 6061T6 ANGLE 1.00 x 1.00 x .125W | 9/15/10<br>Yes | 40.00<br>f | Yours ppd | $0.6000 | $24.00 |
| | | **Special Inst:** | MATERIAL: 6061-T6 OR T6510/T6511<br>ALUMINUM ANGLE<br>AS PER AMS-QQ-A-200/8 | | | | |

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

POSITIVE RECALL
EFFECTIVE 10-9-17 AUTH CL
RELEASED AL DATE 10/9/17

**PO Total:** **$1,024.00**

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

**Change Nbr:** 1 **Change Date:** 9/10/10

P009642

C8307

# YIEH CORPORATION LIMITED

## INSPECTION CERTIFICATE

ERTIFICATE NO.: SK-99040

USTOMER: MAGNA STAINLESS INC(DIV OF CANADIAN SPECIALTY METALS INC.)

NVOICE NO.: SSCAE40302TE9

REDIT NUMBER: I700625

ESCRIPTION: STAINLESS STEEL SHEETS

JUN 01 2010

| P/L NO. | SIZE | PCS | N.W. (KG ) | SPEC | HEAT NO. | REFERENCE NO. |
|---|---|---|---|---|---|---|
| 59 | 0.9mm (20ga) X 1219mm (48") X 3048mm (120") | 86 | 2256 | 304 / 2B | A0639-2010 | F8055 |
| 60 | 0.9mm (20ga) X 1219mm (48") X 3048mm (120") | 86 | 2259 | 304 / 2B | A0639-2010 | F8055 |
| 61 | 1.2mm (18ga) X 1219mm (48") X 2438mm (96") | 87 | 2428 | 304 / 2B | B7113-1020 | F8209 |
| 62 | 1.2mm (18ga) X 1219mm (48") X 3048mm (120") | 64 | 2232 | 304 / 2B | B7113-1020 | F8209 |
| 63 | 1.2mm (18ga) X 914mm (36") X 3048mm (120") | 51 | 1342 | 304 / 2B | YU256274 | 93S51062B |
| 64 | 1.5mm (16ga) X 1219mm (48") X 2438mm (96") | 70 | 2433 | 304 / 2B | A0587-3030 | F8139 |
| 65 | 1.5mm (16ga) X 1219mm (48") X 2438mm (96") | 70 | 2434 | 304 / 2B | A0587-3030 | F8139 |
| 66 | 1.5mm (16ga) X 1219mm (48") X 2438mm (96") | 70 | 2435 | 304 / 2B | A0587-3030 | F8139 |
| 67 | 1.5mm (16ga) X 1219mm (48") X 2438mm (96") | 58 | 2013 | 304 / 2B | A0587-3030 | F8139 |
| 68 | 1.5mm (16ga) X 1219mm (48") X 3048mm (120") | 51 | 2218 | 304 / 2B | A0587-3030 | F8139 |

### Chemical Composition

| P/L NO. | C | Si | Mn | P | S | Ni | N | Cr | Mo |
|---|---|---|---|---|---|---|---|---|---|
| 59 | 0.048 | 0.526 | 1.139 | 0.031 | 0.006 | 8.136 | 0.0590 | 18.0510 | - |
| 60 | 0.048 | 0.526 | 1.139 | 0.031 | 0.006 | 8.136 | 0.0590 | 18.0510 | - |
| 61 | 0.047 | 0.447 | 1.207 | 0.032 | 0.004 | 8.017 | 0.0500 | 18.1500 | - |
| 62 | 0.047 | 0.447 | 1.207 | 0.032 | 0.004 | 8.017 | 0.0500 | 18.1500 | - |
| 63 | 0.043 | 0.520 | 1.110 | 0.030 | 0.001 | 8.100 | 0.0250 | 18.1300 | - |
| 64 | 0.046 | 0.421 | 1.183 | 0.029 | 0.005 | 8.133 | 0.0560 | 18.1880 | - |
| 65 | 0.046 | 0.421 | 1.183 | 0.029 | 0.005 | 8.133 | 0.0560 | 18.1880 | - |
| 66 | 0.046 | 0.421 | 1.183 | 0.029 | 0.005 | 8.133 | 0.0560 | 18.1880 | - |
| 67 | 0.046 | 0.421 | 1.183 | 0.029 | 0.005 | 8.133 | 0.0560 | 18.1880 | - |
| 68 | 0.046 | 0.421 | 1.183 | 0.029 | 0.005 | 8.133 | 0.0560 | 18.1880 | - |

### Mechanical Test

| Y.S.(0.2%) N/mm2 | T.S. N/mm2 | Elongation % | HRB |
|---|---|---|---|
| 283 | 640 | 54.3 | 80.6 |
| 283 | 640 | 54.3 | 80.6 |
| 295 | 629 | 54.7 | 82.0 |
| 295 | 629 | 54.7 | 82.0 |
| 306 | 685 | 51.0 | 87 |
| 303 | 643 | 53.3 | 85.7 |
| 303 | 643 | 53.3 | 85.7 |
| 303 | 643 | 53.3 | 85.7 |
| 303 | 643 | 53.3 | 85.7 |

emark: 1.We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

YIEH CORPORATION LIMITED

Q.C. MANAGER

# MAGNA

**Magna Stainless**
5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

## PACKING LIST

 I032442

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

MAGNA Qc 6

SPECIAL INSTRUCTIONS
*****STOCK***

Contact: C.LAVOIE

Ship Terms: PREPAID

MTR:Y

| Currency | Sales Person | Customer Phone | Customer Fax | Customer PO |
|---|---|---|---|---|
| CANADIAN DOLLARS | DAVE MC VETY | (613) 632-5200 | (613) 632-1053 | 12546 |

| Sales Order | Terms | Ship Via | Date Ordered | Date Required | Date Shipped |
|---|---|---|---|---|---|
| W035566 | NET 30 DAYS | NIR:R-557065-1 | 09/16/10 | 09/17/10 | 09/17/10 |

| Ordered | Back Ordered | Unit | Description | Bundle # | Heat # | Shipped |
|---|---|---|---|---|---|---|
| 2 | | PC | ALUMINUM ANGLES<br>AAN 6061 T6 1" x 1" x 1/8" x R/L<br>20' 12 LB / 2 PC | L042208 | 2BM307 CL 10/19/17 | 2<br>2 |
| 5 | | PC | STAINLESS SHEET<br>SSH 304 2B 16ga x 48" x 96"<br>420 LB / 5 PC<br>CL 10/19/17 | L040896 | A0587-3030 | 5<br>5 |
| Bundles: 1 | Skids: 1 | | | Approx | Weight: | 432 LB |

Received by:_____ Date:_____ Signature:_____

# Purchase Order Receipt Listing



*Monday, September 20, 2010 6:54:56 AM*

All amounts are calculated in domestic currency.

All Vendors PO ID PO12546 Receipt Dates from 9/20/2010 to 9/20/2010 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

| Purchase Order ID/ Curr Type | Line Nbr/ Insp Req | Project ID | Reference/ Description/ Cert Std | PO U/M / Stock U/M | Required Date Required Qty | Recv Date/ Recv Emp | Recv Qty (PO U/M) | Cost Per Unit/ Recv Value | Inspected Qty/ Rejected Qty (PO U/M) | MRB Qty/ MRB Reject Qty | Book Amt |
|---|---|---|---|---|---|---|---|---|---|---|---|
| **VendorID\Vendor Name** | | **VC-MAG002** | **Magna Stainless** | | | | | | | | |
| PO12546 | 2 | | M304S16GA | sf | 9/15/2010 | 9/20/2010 | 160.0000 | $5.25 | 0.0000 | 0 | $840.00 |
| CAD | No | | 304/316 Sheet .063 115688 | sf | 160.0000 | DESJ02 | | $840.00 | 0.0000 | 0 | |
| | 3 | | M6061T6A1.000W.125 | f | 9/15/2010 | 9/20/2010 | 40.0000 | $0.60 | 0.0000 | 0 | $24.00 |
| | No | | 6061T6 ANGLE 1.00 x 1.00 x .125W 115688 | f | 40.0000 | DESJ02 | | $24.00 | 0.0000 | 0 | |

| | |
|---|---|
| **Total Received Quantity:** | 200.0000 |
| **Total Qty to Inspect (PO U/M):** | 0.0000 |
| **Total Reject Quantity:** | 0.0000 |
| **Total Receipt Value:** | $864.00 |
| **Total Balance Due Quantity:** | 0.0000 |

# Receiving Report

Date: 10/9/17 Batch No: IM115688

Supplier: Magna Dart P/O: 12546

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ✓
Receipt: Cash ___ Cr ___

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ___ No ✓
Shipment Complete: Yes ___ No ✓ N/A ___
QC6 Inspection ___ N/A ___
Work Order ~~16647~~ N/A ___

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|---|---|---|---|---|---|---|
| 303R 1" | | 24 | 0 | 0 | 24 | |
| | | | | | | |
| | | | | | | |

**Initials of receiver (if shipment OK)** Level 12 CZ

Production/Admin: 10/9/20
Date
Received/Costing
Initial

Location ___

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

| DART AEROSPACE LTD | Work Order: | 62301 |
|---|---|---|
| | | |
| Description: Door Doubler | Part Number: | D4108-1 |
| | | |
| Inspection Dwg: D4108-1 Rev: A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø .128 | +.005 - .001 | .130 | * | | V B02 | |
| Ø .375 | +.006 - .001 | .375 | * | | V | |
| Ø .386 | +.006 - .001 | .386 | * | | V | |
| 5.85 | +/- .030 | 5.844 | * | | V | |
| 5.60 | +/- .030 | 5.595 | * | | V | |
| .80 | +/- .030 | .800 | * | | V | |
| .406 | +/- .010 | .401 | * | | V | |
| .254 | +/- .010 | .255 | * | | V | |
| .490 | +/- .010 | .490 | * | | V | |
| .60 | +/- .030 | .600 | * | | V | |
| .38 | +/- .030 | .379 | * | | V | |
| .375 | +/- .010 | .376 | * | | V | |
| 1.10 | +/- .030 | 1.101 | * | | | 8 10/10/17 |
| .508 | +/- .010 | .510 | * | | V | |
| 3.50 | +/- .030 | 3.498 | * | | V | |
| .87 | +/- .030 | .872 | * | | V | |
| .25 | +/- .030 | .250 | * | | V | |
| .25 | +/- .030 | .250 | * | | V | |
| .80 | +/- .030 | .796 | * | | V | |
| 2.13 | +/- .030 | 2.126 | * | | V | |
| .71 | +/- .030 | .708 | * | | V | |
| 2.63 | +/- .030 | 2.636 | * | | V | |
| .063 | +/- .010 | .059 | * | | V | |

| Measured by: | JB |
|---|---|
| Date: | 10-9-17 |

| Audited by: | S |
|---|---|
| Date: | 10/09/17 |

| Prototype Approval: | N/A |
|---|---|
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | KJ/JLM | |

Dart Aerospace Ltd

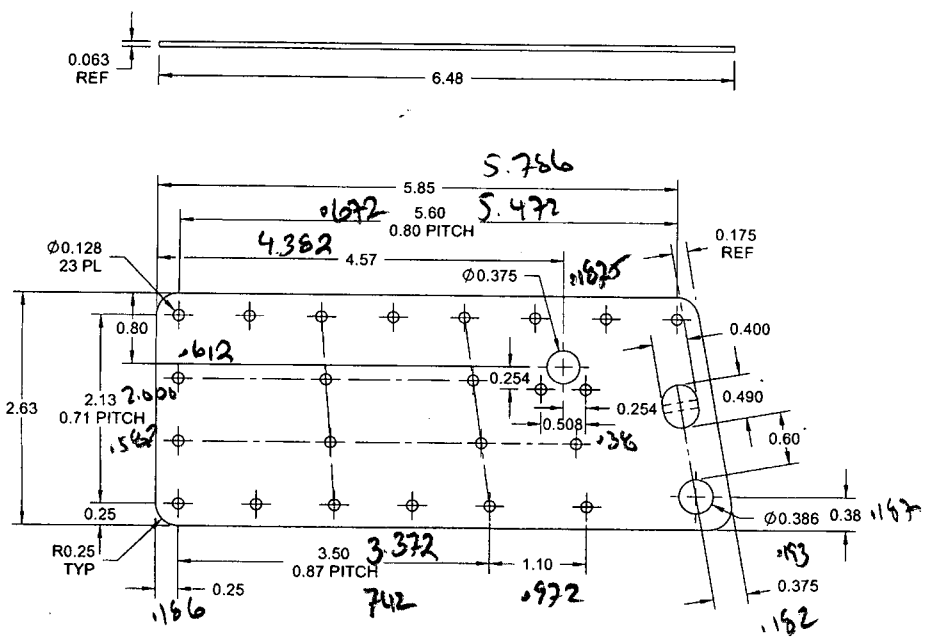
| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

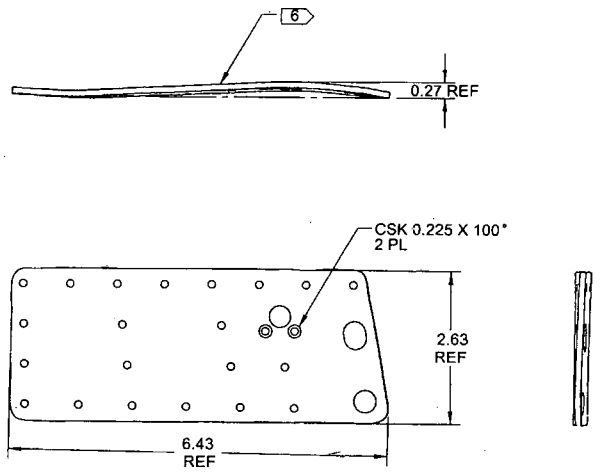
**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries




**D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER**




**D4108-1 LEFT PASS DOOR DOUBLER** 8
**(MAKE FROM D4108-1F)**

#62301

RELEASED
2010-09-23

NOTES:
1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-1 : MAKE FROM D4108-1F.
2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION -1 : IDENT P/N D4108-1 & B/N PER QSI 044 6.1
7) WEIGHT: 0.29 lbs
8) FORM & INSPECTION PER TEMPLATE DT9648.

| | | |
|---|---|---|
| DESIGN | JPH | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | JPH | |
| CHECKED | | DRAWING NO. D4108 REV. A |
| MFG. APPR. | | SHEET 2 OF 7 |
| APPROVED | | TITLE DOUBLERS & FITTINGS SCALE NTS |
| DE APPR. | | |
| DATE | 10.07.20 | |

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Dart Aerospace Ltd

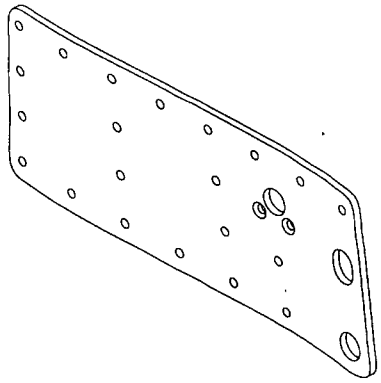
| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

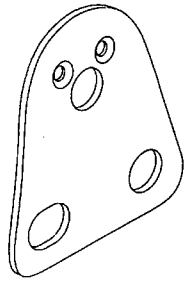
**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

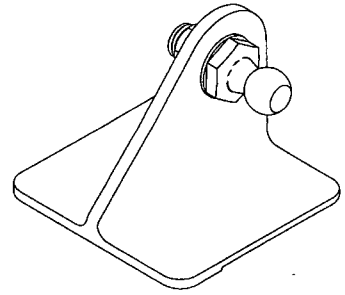
**NOTE:** Date & initial all entries



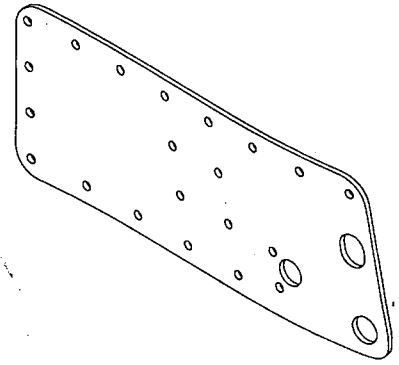
D4108-1 LEFT PASS DOOR DOUBLER



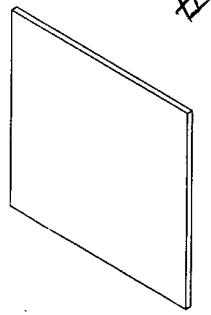
D4108-5 SMALL RIGHT DOOR DOUBLER



D4108-047 SILL BRACKET ASSEMBLY

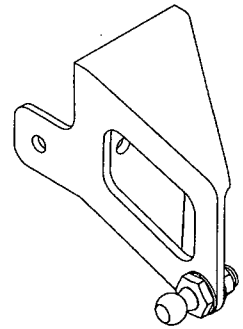


D4108-3 RIGHT PASS DOOR DOUBLER



#62301

D4108-11 TEMPLATE



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
2010 -09- 23

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| A | NEW ISSUE | JPH | 10.07.20 |

| | | |
|---|---|---|
| DESIGN | JPH | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | JPH | |
| CHECKED | | DRAWING NO. D4108 REV. A |
| MFG. APPR. | | SHEET 1 OF 7 |
| APPROVED | | TITLE DOUBLERS & FITTINGS SCALE NTS |
| DE APPR. | | |
| DATE | 10.07.20 | |

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*Friday, September 24, 2010 3:26:57 PM*



**Work Order ID:** 62301

**Parent Item:** D4108-1

**Parent Item Name:** Door Doubler, Left

**Start Date:** 9/27/2010 **Required Date:** 10/4/2010

**Start Qty:** 3.00 **Required Qty:** 3.00

**Comments:** IPP Rev:A 10.09.24 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304S16GA<br>304/316 Sheet .063 | | Purchased | No | | | 100 | sf | 153.2400 | 0.1183 | 0.373579 | 1 5A<br>1B 10-9-37 | | |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| MAT | | 146.7 | | |
| | 111323 | 0 | | |
| | 115688 | 146.7 | | 115689 |
| MAT20 | | 6.54 | | |
| | 115440 | 6.54 | | |

5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Work Order ID 62301

*Friday, September 24, 2010 3:26:57 PM*

**Item ID:** D4108-1 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Door Doubler, Left

**Start Date:** 9/27/2010 **Start Qty:** 3.00 **Cust Item ID:**

**Required Date:** 10/4/2010 **Req'd Qty:** 3.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150 | Identify as per dwg ~~& Stock~~ Location: 129 | 0.00 | | | | 10.10.12 | | 5 | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | 10.10.12 | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10-10-12 5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Work Order ID 62301

*Friday, September 24, 2010 3:26:57 PM*

**Item ID:** D4108-1 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Door Doubler, Left

**Start Date:** 9/27/2010 **Start Qty:** 3.00 **Cust Item ID:**

**Required Date:** 10/4/2010 **Req'd Qty:** 3.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 QC Quality Control | QC8- Inspect parts - second check | 0.00 | | | | x5 | | | |
| | **Memo** | 0.00 | | | | | | | |
| | 10/09/27 to Rev A. | | | | | | | | |
| 130 Small Fab Small Fab | | 0.00 | | | | 10/09/28 5 | | | |
| | **Memo** | 0.00 | | | | | | | |
| | 1- C'sink holes as per dwg<br>2- Use press to start forming D4108-1 as per dwg using DT9648. Then finish the shape of D4108-1 by hand. | | | | | SB 10/10/05 | | | |
| 140 QC Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | **Memo** | 0.00 | | | | x5 | | | |
| | ***Use DT9648 for inspection*** | 10/10/06 | | | | | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Work Order ID 62301

*Friday, September 24, 2010 3:26:57 PM*



**Item ID:** D4108-1 **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Door Doubler, Left

**Start Date:** 9/27/2010 **Start Qty:** 3.00 **Cust Item ID:**

**Required Date:** 10/4/2010 **Req'd Qty:** 3.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** MF **Date:** 10-9-24 **Tooling:** **Date:** **Run Start**

**QC:** **Date:** **SPC (Y/N):** **Date:** **Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| Draw Nbr: D4108 / Revision Nbr: A | | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| Waterjet | | | | | | | | | |
| FLOW CNC Waterjet | **Memo** | 0.00 | | | | | | | |
| 304 . 063 | 1-Cut as per Dwg<br>Dwg Rev: A<br>Prog Rev: 1 | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | **Memo** | 0.00 | | | | | | | |

B10-9-27

B10-9-27

MATERIAL CERTIFICATION REQ'D UPON DELIVERY
CS 10/9/24